

15

Date: Wednesday, 3/12/2008 1:59:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY
 Job Number : 37895
 Estimate Number : 11999
 P.O. Number :
 This Issue : 3/12/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D350591122
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2351 UNDER REVIEW *08-03-12*
 Previous Run : 36602 Project Number : N/A
 Material :
 Due Date : 4/7/2008 Qty: *3* Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP K
 J/Rf

Additional Product

Job Number:



Seq. #: Machine or Operation: Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-122 CHG003 *08/04/24*

2.0

D2244116

Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total: 0.5000 Each(s)
 Pick:

Qty Part Number Description Batch
 0.5 D2244-116 Extrusion *B33733*

*SAD 08/04/01**(2)*

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

*SAD 08/04/01**(2)*

4.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/01 (x2)

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg

EL 8-41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/08 (V2)

7.0

D28502

End Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2850-2 End Bracket 329849

08.04.07 2

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod ~~M106734~~
M106762

3-Do not Grind Flush

08.04.07 2
08.04.07 2
08.04.07 2

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-04-07 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/07 (V2)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/04/08

(2X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-09 (2)

W/O:		WORK ORDER CHANGES					
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Drawing Name: SHORT STEP ASSEMBLY

Job Number: 37895

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2582

Step Leg Assy

B37 925

SAD 02/04/15 (2)

14.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3 Rivet

M104 345

SAD 02/04/15 (2)

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

SAD 02/04/15 (2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 02/04/15 (2)

17.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate

B35 887

SAD 02.04.17 2

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R

Aluminum Rod M106 834

SAD 02.04.17 2

2-Grind end plate flush.

SAD 02/04/19 (2)

W/O:		WORK ORDER CHANGES					
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Job Number: 37895

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.04.21 (2)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.04.21 (2)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

BR 08-04-21 30 min.

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

BR 08-04-23

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch:

M 107385

M-L 08/04/24

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.04.24 (2)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22301

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Packing Kit Qty Part Number Description Batch
1 D2230-1 Mounting Lug 36747

8/4/23

(2X)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D22303

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch
1 D2230-3 Mounting Lug 37152

28.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)

Pick:

Packing KitQtyPart Number Description Batch
1 D2856-400 7.20" Abrasion Strip 36161

29.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch
2 AN3-37A Bolt 105425

30.0

AN413A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch
3 AN4-13a Bolt 107321

31.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch
4 AN960JD10 Washer 107715

32.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch
6 AN960JD416 Washer 107321

8/4/23

2x

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 37895

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

2 MS21042L3 Nut (or -3)

106883

SP

34.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Packing KitQtyPart Number Description Batch

3 MS21042L4 Nut (or -4)

106051

8/4/23

SP

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/04/24

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-122

Location:

PPP Rev:

Rev D

AS 08/04/24

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/24

Job Completion



MF 08-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN KE	DRAWN BY RH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 37895

RELEASED
05.11.28

UNDER REVIEW

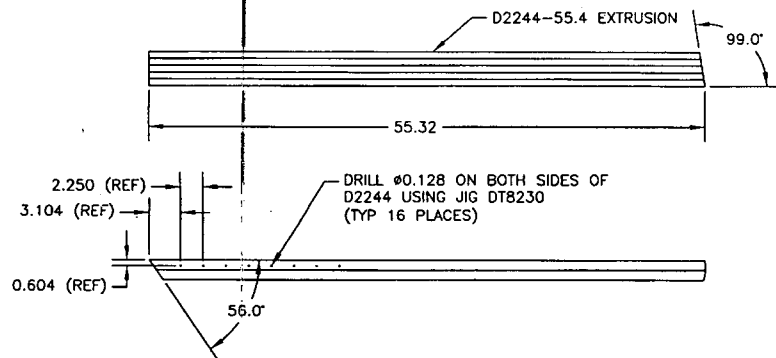
08.03.12

07.11.21
P62 P62# 263

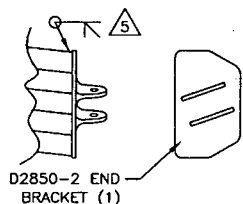
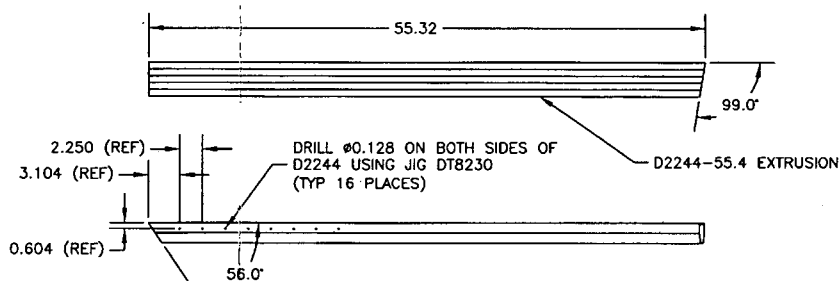
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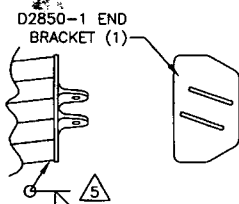
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



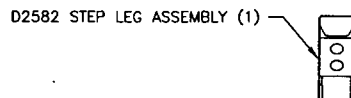
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



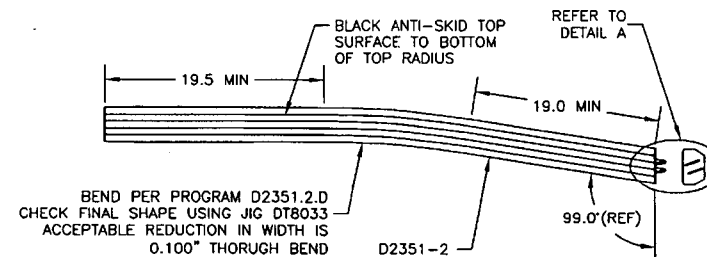
DETAIL B
SCALE: 1:4



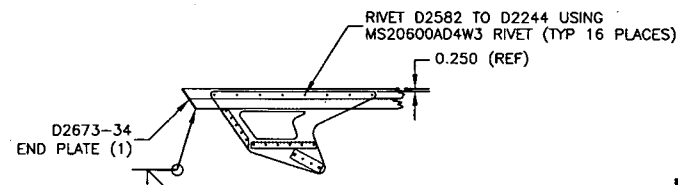
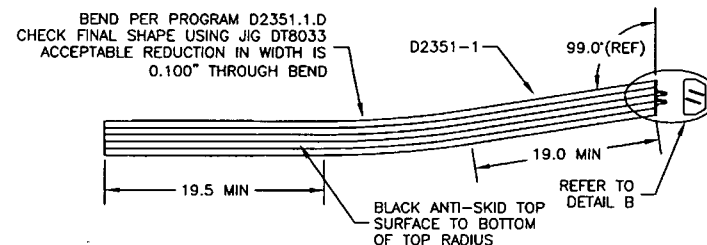
GENERAL NOTES

- 1) WELD PER DART QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



RELEASED
05.11.28

UNDER REVIEW

08.03.12

09.11.21

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CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 2 OF 2
DATE 05.11.14	TITLE HIGH FLOAT STEP ASSEMBLY	SCALE 1:12	

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ENGINEERING
RETURN TO
37895

